Work Order ID 59191

May 27, 2010, 1:29:30 PM

Page 1

Item ID:	D3955-7			A	Accept				s s	etup S	tart	
Revision ID: Item Name:	Plate									s	top	
Start Date: Required Date:	5/27/10 6/02/10	Start Qty: 12.00 Req'd Qty: 12.00				Cust Item I Customer:	D:					
Reference:										~		A S (A A A A A A A A A
Approvals:	Process Pla	n: \	Date:	,	Tooling:	Da	ite:		R	,	tart	
	QC:	-	Date:		SPC (Y/N):	Da	ıte:			S	top	
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3955	A		;									
100					0.00					· · · · · · · · · · · · · · · ·		
Waterjet		Memo			0.00					10-5.	-27	
FLOW CNC Waterj	et	1-Cut as p Dwg Rev: Prog Rev:		5	••••							
110		OC2- Inspect parts off	machine FAI/F	AIB	0.00							

Memo

0.00

1810-5-27

Quality Control

W/O:			WC	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·					
Part No) :	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:_	Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C Cld	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)		-
DATE	STEP	Description of NC			tion B	Verificati	on Approval	Approval
DAIL	J,Lr	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (QC Inspector
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					1-		·	
		·						

NOTE: Date & initial all entries

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Work Order ID 59191

May 27, 2010 1:29:30 PM



Page 2

Item ID:

D3955-7

Accept



Setup Start



Revision ID:

Item Name:

Required Date: 6/02/10

Plate

5/27/10

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Date:_

Tooling:

0.00

0.00

0.00

SPC (Y/N):

Date:

Run

Start Stop

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00

Date: Tool ID

Tool # Plan Code

Accept **Oty**

Reject Qty

Reject Number Stamp

Insp.

130

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/01HJ

W/O:	Tospace		WO	RK ORDER CH	ANGES			,				
DATE	STEP	PRO	CEDURE CHAN		ANGEO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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							<u> </u>					
	<u> </u>]				
Part No):	PAR #:	PAR #: Fault Category: No									
Resolution:			Disposition	•	QA	: N/C CId	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFO	PRMANCE	(NCR)			· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	Description of NC		Corrective Action Section Initial Action Description		on B Sign &		cation	Approval	Approval		
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector		
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NOTE: Date & initial all entries

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Picklist Print

May 27, 2010 1:29:29 PM

Work Order ID: 59191

Parent Item: D3955-7

Parent Item Name:

Plate

Comments:

IPP RevA: New issue DD verified by:EC



Start Date: 5/27/10

Required Date: 6/02/10

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No				sf ·	44.6800	0.3545	4.477895	5.	· .	
											1810-	5->7	

304/316 0.125 Sheet

Location Loc Qty Loc Code 44.68 MAT 114488 44.68

(14488



Page 1

W/O:		WORK ORDER CHANGES										
DATE	STEP	•	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	Date:			
	R	esolution:	Disposit	Disposition: QA: N/C Closed: Date:					Date:			
NCR:	,	V	VORK OR	DER NON-CON	FORMANC	E (NCR)	,				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Actio Action Des Chief E	cription	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector		
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DART AEROSPACE LTD	Work Order: 5	9191
Description: Plate	Part Number:	D3955-7
Inspection Dwg: D3955 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

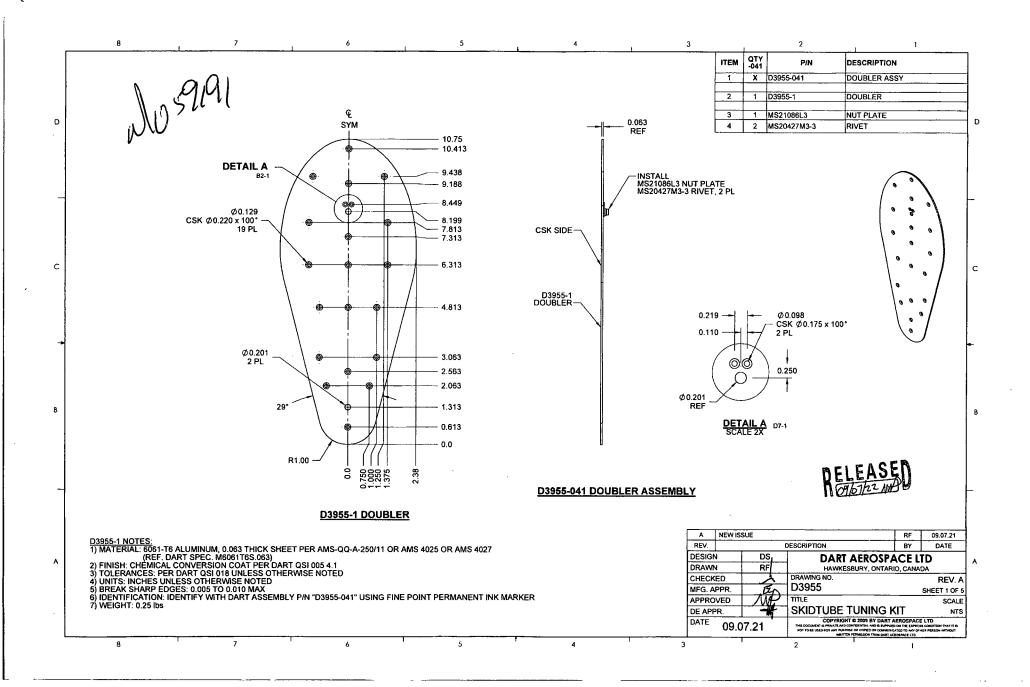
X First Article Prototype

		·						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.201	+0.005/-0.001	£06,	W	-				
1.31	+/-0.030	1.311	¥					
10.75	+/-0.030 (10.751	4					
6.886	+/-0.010		9					
4.75	+/-0.030	4,750	9			*** * **		
0.120	+/-0.010	्।(१	>					
						, -		
								

Measured by:	退	Audited by:	2	Prototype Approval:	N/A
Date:	10-5-27	Date:	10/15/28	Date:	N/A

Rev	Date	Change	Revis	sed by	Approved
Α	09.07.29	New Issue	KJ	۱۸	
В	09.11.04	Dimension 0.120 was 0.125	KJ	THE	Δ <u>Δ</u>
		·			

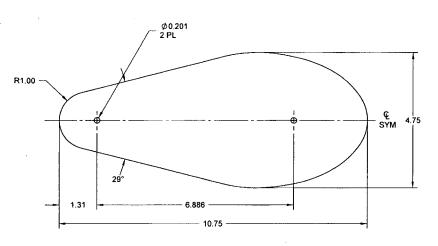
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W/O:			V	ORK ORDE	R CHANGES	; ;				
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	r	ICR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:		A: N/C C	losed:		Date: _	····
NCR:		·	WORK OR	DER NON-C	ONFORMAN	CE (NCI	R)			
DATE	STEP	Description of NC	Initial Action Description				Verific	ation	Approval	Approval
		Section A	Chief Eng		Description hief Eng	Sign Date		on C	Chief Eng	QC Inspector
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	_ QA: N/C C	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description	on B Sign Date	Section C		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	•			
						-		·	
				•					
				-					

SYM - 10.75 D D APPLY ANTI-SKID ON ONE SIDE ONLY 8.199 29° - 1.313 Ø0.201 2 PL 0.0 R1.00 2.38 **D3955-3 COVER PLATE** NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs DESIGN DS, DART AEROSPACE LTD RF DRAWN HAWKESBURY, ONTARIO, CÀNADA DRAWING NO. CHECKED REV. A D3955 MFG. APPR. SHEET 2 OF 5 TITLE APPROVED SCALE SKIDTUBE TUNING KIT DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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W/O:			. V	ORK ORDER CHANGE	S						
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				<u>.</u>							
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR:	Yes N	10 DQ /	A:	Date:		
			_ Disposit	Disposition: QA: N/C Closed:					Date:		
NCR:		. W	ORK OR	DER NON-CONFORMA	NCE	(NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section			Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng		Date					
		·									
			,								



D3955-X PLATE

General Table							
P/N	T (in)	T (GA)	WEIGHT (lbs)				
D3955-5	0.060	16	0.64				
D3955-7	0.120	11	1.28				

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'TGA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: SEE TABLE

DESIGN	DS,	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO.	REV. A				
MFG. APPR.	180	D3955	SHEET 3 OF 5				
APPROVED	M	TITLE	SCALE				
DE APPR.	-#	SKIDTUBE TUNING KIT	NTS				
DATE 09.0	7.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPORTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON CONTED ON COMMUNICATED TO ANY OTHER PETROIS WITHOUT WRITTER PERMISSION FOR DUPLET AEROSPACE LTD.					

W/O:			WC	ORK ORDER CHA	NGES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							-		
	-				NCR: Yes No DQA: Date: QA: N/C Closed: Date: NFORMANCE (NCR) Date: Verification Section C Chief Eng QC				
Part No);				NCR: Yes	No DQ	Date:		
NCR:			WORK ORD	ER NON-CONFOR	RMANCE (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action		Varitication Asset			vai Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Descripti Chief Eng		St Secti	ion C	Chief Eng	QC Inspector
			-						
1									

€ SYM - 0.063 REF - 10.69 Ø0.209 - 8.169 29° 1.283 Ø0.209 0.0 R0.97 2.35 **D3955-21 GASKET** D3955-21 NOTES:

1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER

7) WEIGHT: 0.08 lbs DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3955 MFG. APPR. SHEET 4 OF 5 TITLE APPROVED SCALE SKIDTUBE TUNING KIT

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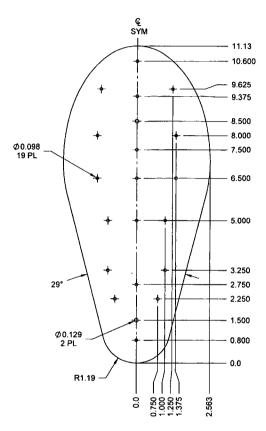
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W/O:			WO	RK ORDER CH	ANGES					···
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
	Re		Disposition:			A: N/C Closed: Date:				
NCR:			WORK ORDE	ER NON-CONFO	RMANCE	(NCR	1)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip Chief Eng Chief Eng		Section B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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D



D3955-23 TEMPLATE

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.16 lbs

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN RF DRAWING NO. CHECKED REV. A D3955 MFG. APPR. SHEET 5 OF 5 TITLE APPROVED SCALE SKIDTUBE TUNING KIT

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DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No):	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	Date:			
	R	esolution:	Disposition: QA: N/C CI				osed: Date:			
NCR:		1		R NON-CONFORM	ANCE (NC	3)				
DATE	STEP	Description of NC		tion B	Verifi	cation	Approval	Approval		
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	ption Sign & Date		ion C	Chief Eng	QC Inspector	
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